

Work Order ID 70458-2

Wednesday, June 08, 2011 7:42:26 PM

Page 1

Item ID: D2573

Accept

Revision ID:

Item Name: Saddle, Aft Out 205

Setup Start

Stop

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/23/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 70458 Double check by: SL ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

SL 11/06/27

10

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

SL 11/06/27

10

φ

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/06/27

10

φ

Work Order ID 70458

Wednesday, June 08, 2011 7:42:26 PM



Page 2

Item ID: D2573	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Saddle, Aft Out 205				
Start Date: 6/16/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 6/23/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00		K.A 11/06/28		10	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				10	0	BR 11-6-28	
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo 117745 START TIME: 7:40 320° FINISH TIME: 8:10	0.00				10	0	BR 11-6-28	

Work Order ID 70458

Wednesday, June 08, 2011 7:42:26 PM



Page 3

Item ID: D2573

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft Out 205

Start Date: 6/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10. MA 11/06/30

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Memo

0.00

Packaging

11/6/30 (10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/30 48
11/06/30

Picklist Print

Wednesday, June 08, 2011 7:42:22 PM

Page 1

Work Order ID: 70458



Parent Item: D2573



Parent Item Name: Saddle, Aft Out 205


Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007  Saddle Billet		Manufactured	No			100	Each	39.0000	1	12		11/06/27	

Location

Loc Qty

Loc Code

MAT042

9

66967

9

MAT045

30

65383

13

65954

17

70678

12

DART AEROSPACE LTD		Work Order:	70V58
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		.500	.499	.501	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.568	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.129	.129	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.239	.240	.239	.240		
W	0.115	0.135		.130	.130	.128	.128		
X	0.308	0.313		.309	.310	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.250	.248		
AE	1.500	1.520		1.513	1.512	1.511	1.511		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.251	.250	.250	.251		
AI	2.000	2.020		2.003	2.002	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<u>SL</u>
Date:	<u>11/06/21</u>

Audited by:	<u>K.A</u>
Date:	<u>11/06/28</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.000		
F	0.490	0.510		.501	.499	.498	.498		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.502	.502	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.569	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.127	.126	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.239	.240	.239	.240		
W	0.115	0.135		.125	.124	.125	.126		
X	0.308	0.313		.311	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.624	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.248	.249	.247		
AE	1.500	1.520		1.511	1.511	1.512	1.511		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.249	.250		
AI	2.000	2.020		2.001	2.001	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	11/06/22

Audited by:	B.A
Date:	11/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	70458
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	110	111	112		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.501	.501	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.502	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.569	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.124	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.127	.125	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.220		
V	0.230	0.250		.240	.240	.241	.240		
W	0.115	0.135		.125	.124	.124	.124		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.248	.248		
AE	1.500	1.520		1.512	1.512	1.511	1.512		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.251	.251		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

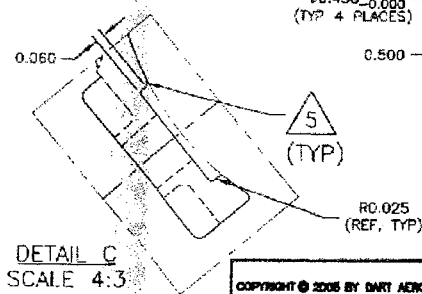
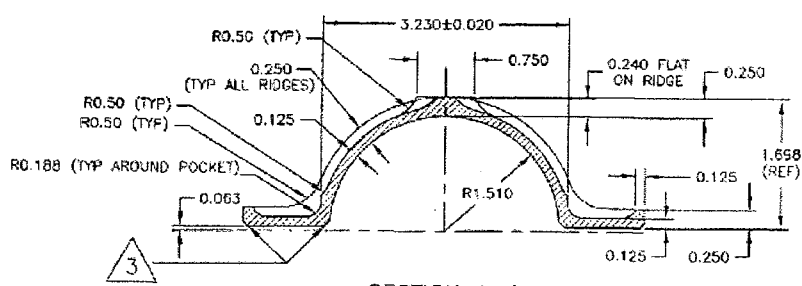
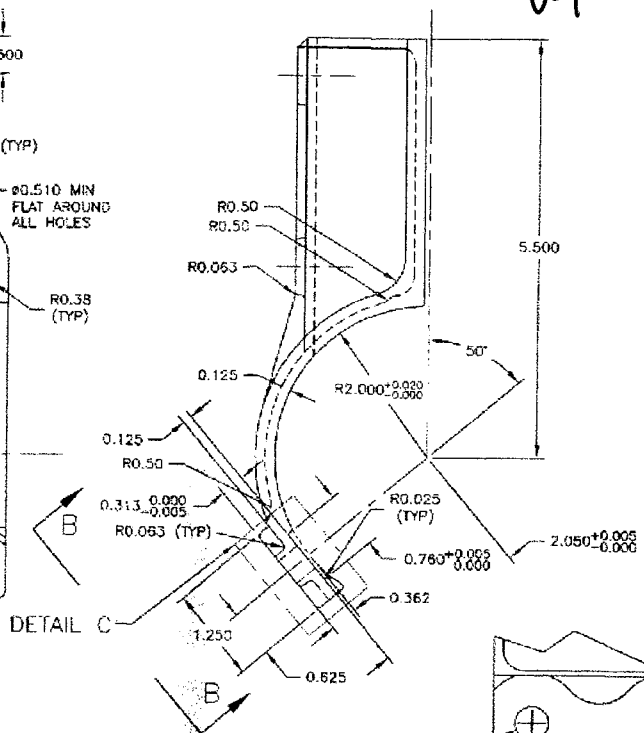
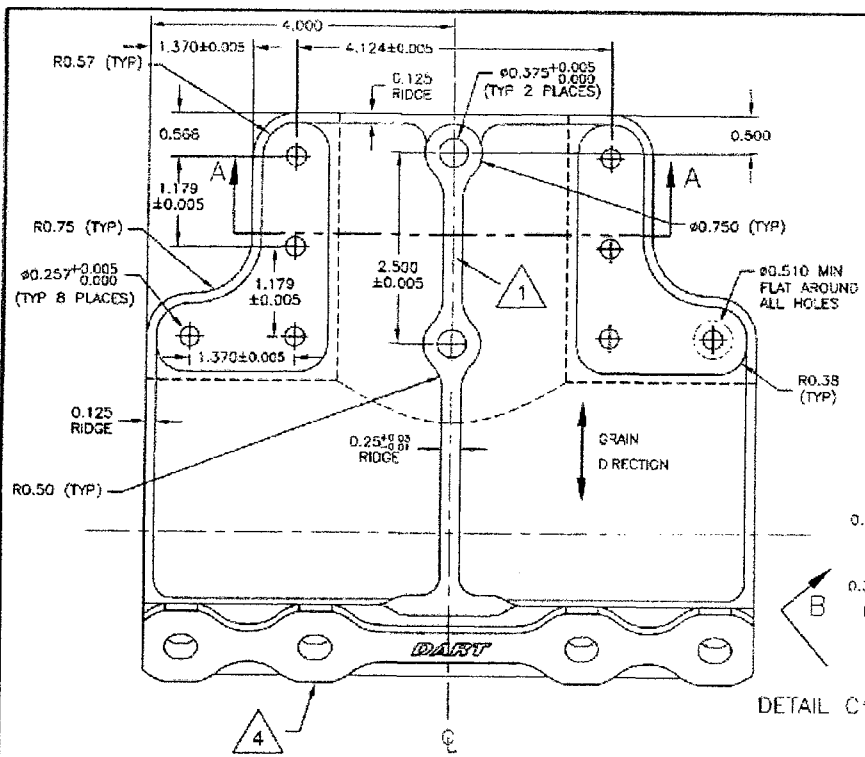
Measured by:	SL
Date:	11/06/23

Audited by:	K.A
Date:	11/06/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/070758

RELEASED
05-12-06

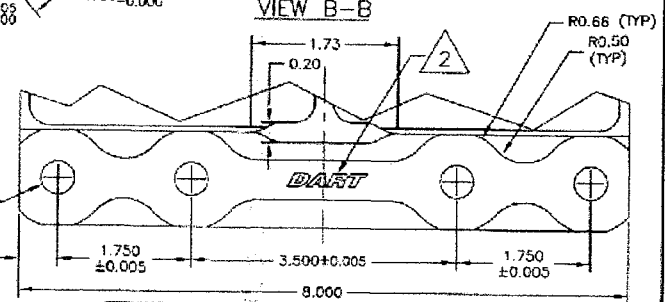


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALUMINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO D2573
		TITLE OUTER AFT SADDLE
		SCALE 2:3

COPYRIGHT © 2005 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

REV. E
SHEET 1 OF 1
SCALE